

Date: Monday, 8/21/2006 2:13:21 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING  
Job Number : 28268B  
Estimate Number : 10395  
P.O. Number : *N/A*  
This Issue : 8/21/2006 S.O. No. : *N/A*  
Prsht Rev. : NC  
First Issue : *N/A* Type : MACHINED PARTS  
Previous Run : 28267B  
Written By :  
Checked & Approved By : *06.08.21*  
Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Part Number : D29685  
Drawing Number : D2968  
Project Number : N/A  
Drawing Revision : B1  
Material : *N/A*  
Due Date : 9/8/2006 Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NT3000W500 4130 Tube 3"ODx.5"W



Comment: Qty.: 0.0218 f(s)/Unit Total : 0.4368 f(s)

Material: AISI 4130 ~~0.5/4"~~ Bar

(M4130N-R0.750)

Identify AS D2968-1

Batch: *M102020*

*S.G 06/09/07*

2.0 MORI SEIKI

MORI SEIKI CNC LATHE LARGE

*RG*



*Issue for turn per day*



*06-08-08*

Comment: MORI SEIKI LATHE

1-Turn Blank as per Folio FA049 and Dwg D2968

2-Deburr, no sharp edges

*Receive + inspect for tensile damage (22)*

3.0

QC8

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*S.G*

*06/09/20*

*(61) \**

4.0

QC8

SECOND CHECK



*N/A*



Comment: SECOND CHECK

*06-09-21*

*21*

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 396*

*06/09/21 (21)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/09/21

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: RING

Job Number: 28268B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*[Signature]* 06/09/21

Job Completion



*u* 06.09.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

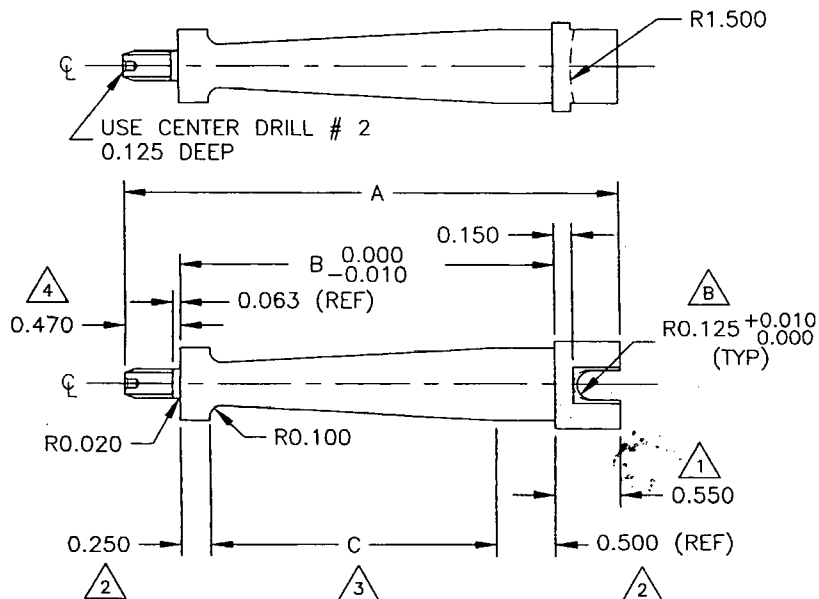
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ 0.750 O.D.

△ 0.625 O.D.

△ MACHINE UNIFORM TAPER FROM 0.363 O.D. TO 0.625 O.D.

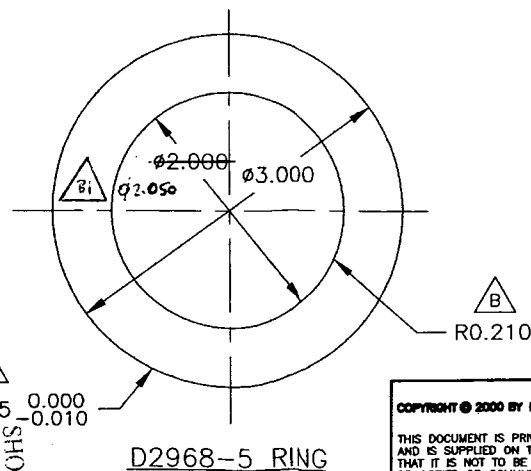
△ 1/4-28 UNF THREAD WITH 0.063 GRIP  
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS  
UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASED

UNDER REVIEW

USE 2968-1 STEM  
FOR -041  
USE 2968-3 STEM  
FOR -043

D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING  
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D2968
DATE	00.05.31	TITLE TOW RING

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
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NO. 28268 B  
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**CERTIFICATE OF CONFORMITY****SOLD TO:**

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

**SHIPPED TO:**

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28318	1987
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28319	1987
40	D2968-5	Ring M4130NT3000W500 M102020 W/O 28267B	1987
<del>20</del> 22	D2968-5	Ring M4130NT3000W500 M102020 W/O 28268B	1987
<del>20</del> 22	D3407-5	Ring M174R3000 M18742 W/O 28333	1987

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shirley Regula Walz

BG 06-09-21

Vankleek Hill, September 20, 2006